

Work Order ID 75816

75816

Page 1

October-31-11 12:42:47 PM

Item ID: D2330-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Base Assembly
 Start Date: 31/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 14/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2330	Rev H

100 0.00

100
 Large Fab Memo 0.00
 Large Fab 1- weld as per dwg D2330 and QSI 004
 S.S Rod batch: 118366

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110
 QC Memo 0.00
 Quality Control

120 QC5- Inspect part completeness to step on W/O 0.00

120
 QC Memo 0.00
 Quality Control

Handwritten notes and signatures:
 12-02-17
 12-02-21
 12-02-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.00							
Hand Finishing									
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	Start Time: 3:30 Oven Temperature: 400°F Finish Time: 4:00								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

IXP M-L 12/02/23

IXP M-L 12/02/23

1 BL 12-2-24

W11A480

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Start Date: 31/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>D206-540-C93. 1B75814</i>	0.00							
150									
Packaging	Memo	0.00							<i>1 BK 12 224.</i>
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							<i>MLJ 12/02/29</i>
Quality Control									

MLJ 12/02/29
①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-31-11 12:42:51 PM

Work Order ID: 75816

75816

Parent Item: D2330-041

D2330-041

Parent Item Name: Basket Base Assembly

Start Date: 31/10/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H02.09.04M304EX0.75-16F was M750-16FXS-S/SKJ
IPP Rev:I 08-09-09 revF as per dwg (ecn 08-522) DD verF by:EC
IPP REV:J 10.11.30 AS PER DWG REV.H DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-107		Manufactured	No			100	Each	15.0000	1	1			
D2012-107									**				
Clevis													

Location

Loc Qty

Loc Code

ST004

15

71602

15

D2235-1		Manufactured	No			100	Each	5.0000	4	4			
D2235-1									**				
Basket Rib													

Location

Loc Qty

Loc Code

WA

1

73202

1

WA005

4

66895

4

D2252-1		Manufactured	No			100	Each	8.0000	2	2			
D2252-1									**				
Frame													

Location

Loc Qty

Loc Code

WA006

8

51941

2

58084

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

October-31-11 12:42:52 PM

Work Order ID: 75816

75816

Parent Item: D2330-041

D2330-041

Parent Item Name: Basket Base Assembly

Start Date: 31/10/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2252-7 Manufactured No

100 Each 8.0000 1 1

D2252-7
Frame

**

Pl 12.02.08

Location

Loc Qty

Loc Code

WA006

8

73080

3

73201

5

①

D2253-1 Manufactured No

100 Each 15.0000 2 2

D2253-1
Lug

**

Pl 12.02.08

Location

Loc Qty

Loc Code

WA005

15

53965

15

②

D2254 Manufactured No

100 Each 46.0000 2 2

D2254
Gussett

**

Pl 12.02.08

Location

Loc Qty

Loc Code

WA005

46

39801

46

②

D2327-3 Manufactured No

100 Each 23.0000 1 1

D2327-3
Spacer Bushing

**

Pl 12.02.08

Location

Loc Qty

Loc Code

WA

23

72963

3

74782

20

B77239 → 1

D2330-1 Manufactured No

100 Each 0.0000 2 2

D2330-1
Frame

**

B75817 → ② Pl 12.02.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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October-31-11 12:42:52 PM

Work Order ID: 75816

75816

Parent Item: D2330-041

D2330-041

Parent Item Name: Basket Base Assembly

Start Date: 31/10/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2330-5 Manufactured No

100 Each 0.0000

1 1

D2330-5

Frame

****B75818 → ① Pl 12.02.08**

D2330-7 Manufactured No

100 Each 1.0000

1 1

D2330-7

Frame

**** Pl 12.02.08**

Location

Loc Qty

Loc Code

WA

1

67335

1

D2581 Manufactured No

100 Each 23.0000

4 4

D2581

Mounting Bracket

**** Pl 12.02.08**

Location

Loc Qty

Loc Code

WA

23

69739

2

70766

2

73762

19

D3748-1 Manufactured No

100 Each 5.0000

3 3

D3748-1

Hinge Half

**** Pl 12.02.08**

Location

Loc Qty

Loc Code

WA

5

68884

5

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 4

October-31-11 12:42:52 PM

Work Order ID: 75816

75816

Parent Item: D2330-041

D2330-041

Parent Item Name: Basket Base Assembly

Start Date: 31/10/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

630.5661

30

30

M304EX0 75-16F

**

Expanded Metal Flat SS

PL 12-0076

Location

Loc Qty

Loc Code

WA

630.5661116

117197

102.9036

117896

53.3264

118153

76.8473

118248

33.0983

118597

29.16788

118955

82.17

119180

253.052632

120318 → 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 75816 M.C.J

11/10/31

RELEASED
2010-11-25

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

H	DIM 0.50 WAS 0.75 (ZN D2-3 & D6-3) REF NCR 10-346	JPH	10.09.28
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/9/13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
DATE	10.09.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

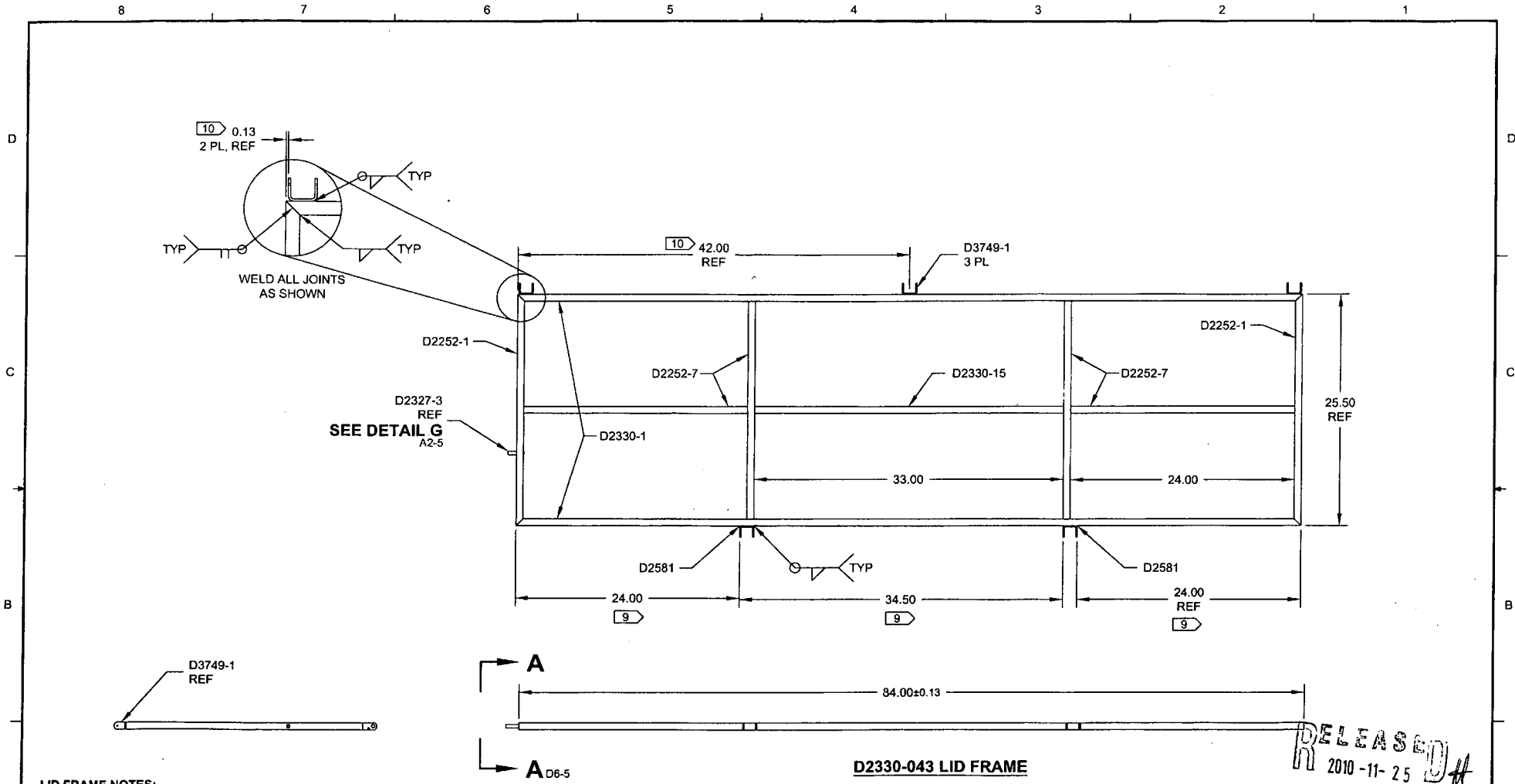
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries

75816



LID FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2330-041 BASKET BASE ASSEMBLY

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
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2010-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2



1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A
8) WELDING: PER DART QSI 004

B_{B7-5} **C**_{A7-5} **D**_{A4-5}

DATE 10.09.28

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2010-11-25

A

W/O:		WORK ORDER CHANGES					
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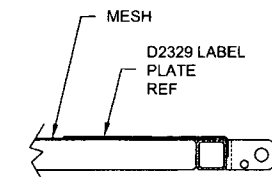
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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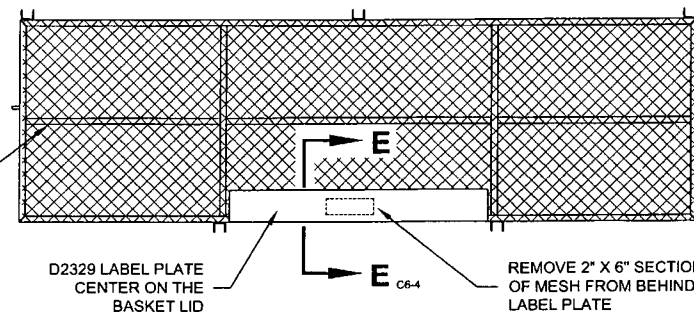
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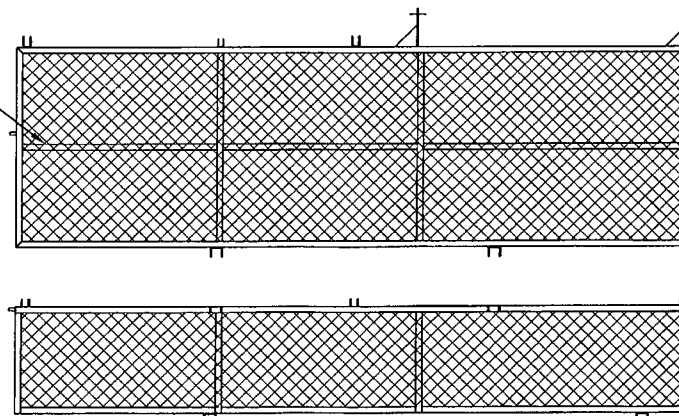
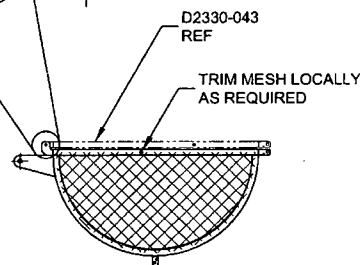
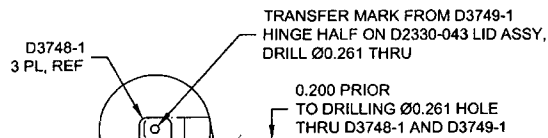


SECTION E-E C3-4
VIEW ROTATED 90° CCW

TACK WELD EACH STRAND END OF MESH TO FRAME





D2330-043 LID ASSEMBLY



D2330-041 BASE ASSEMBLY

ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
DATE	10.09.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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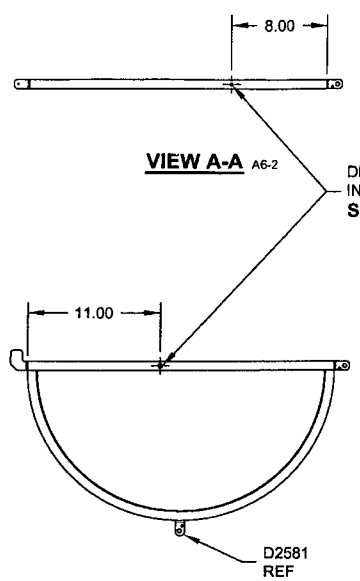
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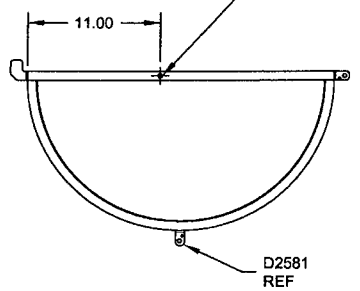
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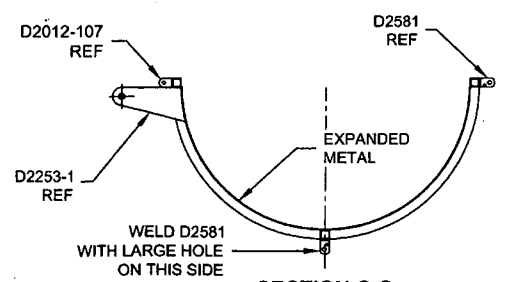
75816



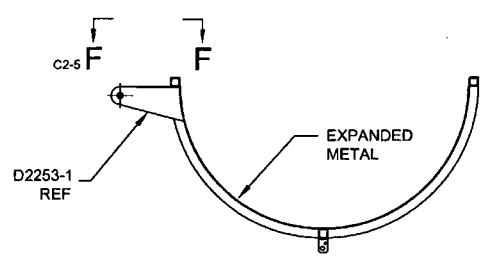
VIEW A-A A6-2
DRILL 3/8 HOLE AND
INSTALL D2327-3
SEE DETAIL G A2-5



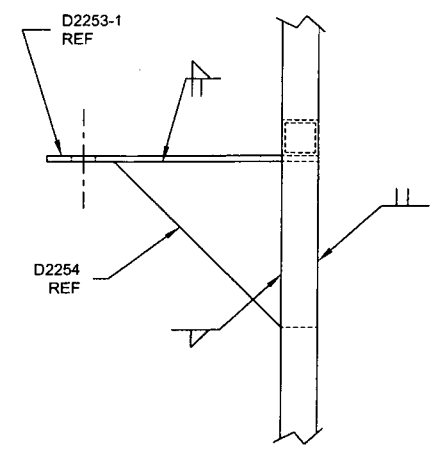
VIEW B-B A5-3



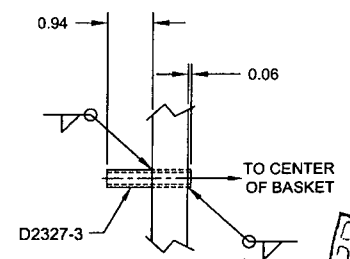
SECTION C-C A4-3



SECTION D-D A3-3



VIEW F-F B6-5
SCALE 4X



DETAIL G
SPACER INSTALLATION
SCALE 4X

RELEASED
2010-11-25

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	L. F. J. P. H.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. H
MFG. APPR.	JP	D2330	SHEET 5 OF 6
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BASKET ASSEMBLY (206B)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

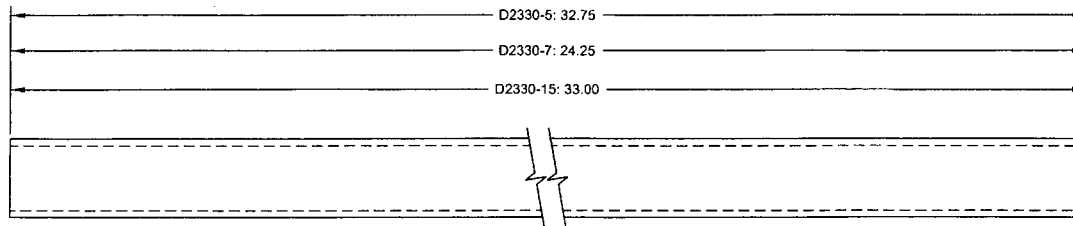
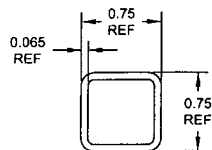
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

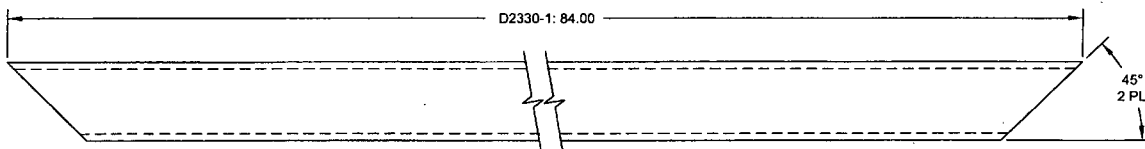
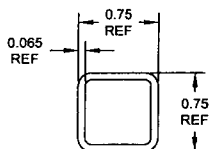
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75816



D2330-5 FRAME
D2330-7 FRAME
D2330-15 FRAME



D2330-1 FRAME

- NOTES:**
- 1) FRAME MATERIAL: SEE SHEET 1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

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